

Work Order ID 105765

Friday, August 16, 2013 12:46:44 PM

105765

ASG

Page 1

Item ID: D3575-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cargo Floor Protector

Stop ***NS2***

Start Date: 8/16/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/16/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *WKF*

Date: *13-8-16*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3575

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

TEXTURE SIDE UP
1-Cut as per Dwg D3575

Dwg Rev: A

Prog Rcv: A

2-Deburr

(1)

13.08.16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(1)

13.06.16

Work Order ID 105765

105765

Page 2

Friday, August 16, 2013 12:46:44 PM

Item ID: D3575-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cargo Floor Protector

Stop *NS2*

Start Date: 8/16/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/16/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

13 8.16

150

Identify as per dwg & Stock Location:

0.00

150

Packaging

Memo

0.00

Packaging

13/8/16 SP

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 13-08-16

MLJ 13-08-16

Picklist Print

Friday, August 16, 2013 12:46:44 PM

Page 1

Work Order ID: 105765

Parent Item: D3575-2

Parent Item Name: Cargo Floor Protector

Start Date: 8/16/2013

Required Date: 8/16/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET | | Purchased | No | | | 100 | sf | 2,531.5920 | 8 | 9.4117647 | | | |

Ac 13-08-16

Location

MAT018

124866

ml26425

Loc Qty

2531.592

286.792

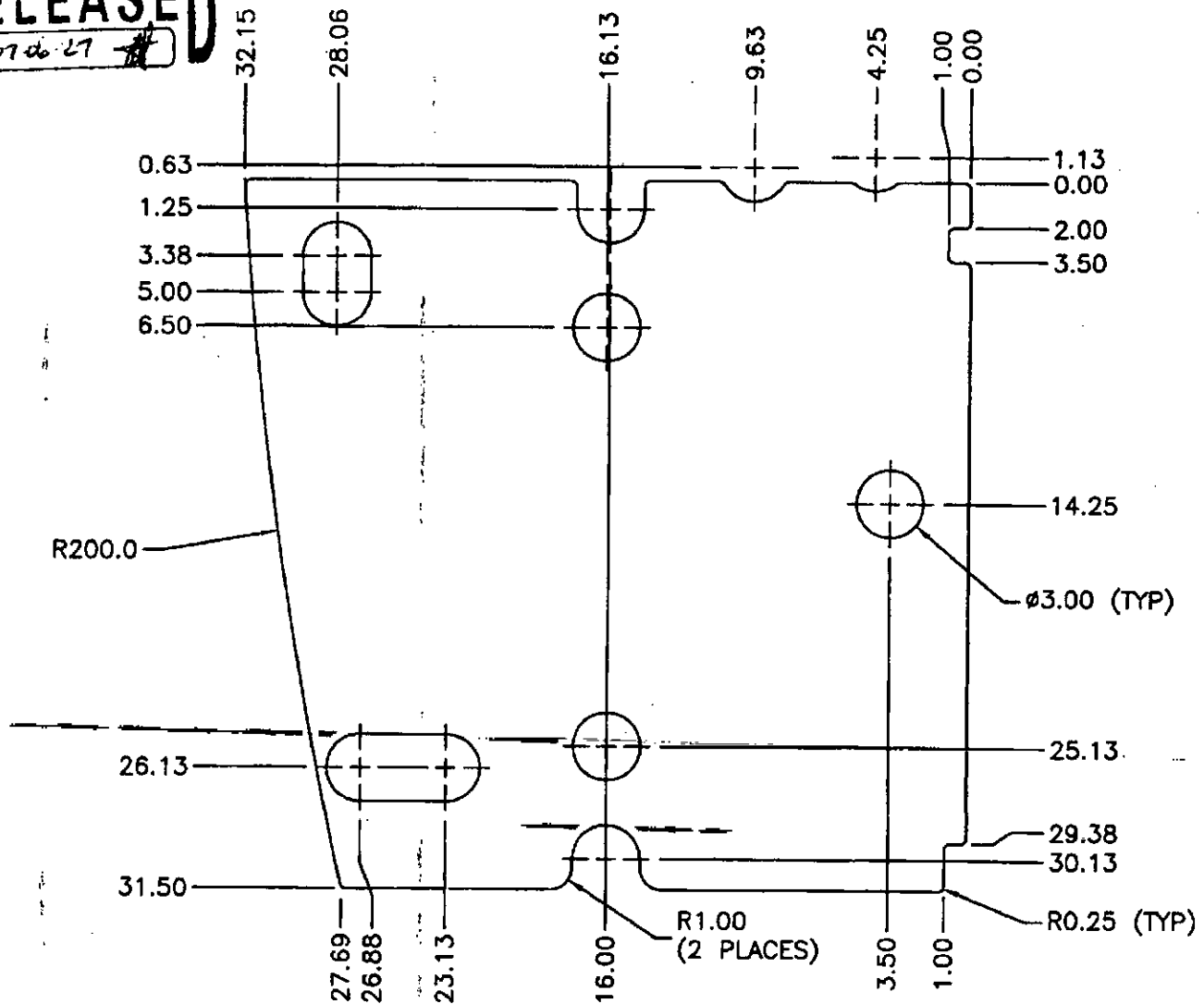
2244.8

Loc Code

126425 → 9.42

| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>LE</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3575 | REV. A SHEET 1 OF 4 |
| DATE 07.06.08 | | TITLE CABIN FLOOR PROTECTOR | SCALE 1:8 |
| A | 07.06.08 | NEW ISSUE | |

RELEASED
07-06-27



D3575-1 CABIN FLOOR PROTECTOR (SHOWN)
D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

| | | |
|--|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 105768 |
| Description: Cabin Floor Protector | | Part Number: D3575-2 |
| Inspection Dwg: D3575 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø3.00 | +0.006/-0.001 | 3.02 | - | | V | JKm-01 |
| 1.00 | +/-0.030 | 1.00 | - | | V | |
| 3.50 | +/-0.030 | 3.50 | - | | V | |
| 16.00 | +/-0.030 | 16.00 | - | | T | JKm-06 |
| 23.13 | +/-0.030 | 23.13 | - | | T | |
| 26.88 | +/-0.030 | 26.88 | - | | T | |
| 27.69 | +/-0.030 | 27.69 | - | | T | |
| 4.25 | +/-0.030 | 4.25 | - | | T | |
| 9.63 | +/-0.030 | 9.63 | - | | T | |
| 16.13 | +/-0.030 | 16.13 | - | | T | |
| 28.06 | +/-0.030 | 28.06 | - | | T | |
| 32.15 | +/-0.030 | 32.15 | - | | T | |
| 2.00 | +/-0.030 | 2.00 | - | | V | |
| 3.50 | +/-0.030 | 3.50 | - | | V | |
| 14.25 | +/-0.030 | 14.25 | - | | T | |
| 25.13 | +/-0.030 | 25.13 | - | | T | |
| 29.38 | +/-0.030 | 29.38 | - | | T | |
| 30.13 | +/-0.030 | 30.13 | - | | T | |
| 1.25 | +/-0.030 | 1.25 | - | | V | |
| 3.38 | +/-0.030 | 3.38 | - | | T | |
| 5.00 | +/-0.030 | 5.00 | - | | T | |
| 6.50 | +/-0.030 | 6.50 | - | | T | |
| 26.13 | +/-0.030 | 26.13 | - | | T | |
| 31.50 | +/-0.030 | 31.50 | - | | T | |

| | | | |
|-------------------------------|------------------------------|----------------------------|-----|
| Measured by: <i>AK</i> | Audited by: <i>27</i> | Prototype Approval: | N/A |
| Date: 13.08.16 | Date: 13.8.16 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-----------------|-----------|
| A | 08.02.29 | New Issue | KJ/DD <i>AK</i> | <i>AK</i> |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | Other |
|---|---|--|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Grain |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Hardware |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete |
| <input type="checkbox"/> Crushed/Crimped | <input type="checkbox"/> Burrs | <input type="checkbox"/> Instructions-Incomplete/Unclear |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Maintenance |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Countersink | <input type="checkbox"/> Mislabeled |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Misread |
| <input type="checkbox"/> Ripples in Bend | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Offset |
| <input type="checkbox"/> Torque Waves in Extrusion | <input type="checkbox"/> Drawing | <input type="checkbox"/> Out of Calibration |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Folio | <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized |
| | | <input type="checkbox"/> Over/Under tolerance |
| | | <input type="checkbox"/> Part Incorrect |
| | | <input type="checkbox"/> Part Lost/Missing |
| | | <input type="checkbox"/> Part Moved |
| | | <input type="checkbox"/> Positioned Wrong |
| | | <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced |
| | | <input type="checkbox"/> Temperature/Cure |
| | | <input type="checkbox"/> Weld |
| | | <input type="checkbox"/> Wrong Stock Pulled |
| | | <input type="checkbox"/> Other |